



Joc<sup>l</sup> LLOYDS. 8-11 8

See separate Plans



SCALE  $\frac{1}{2}" = 1'-0"$  3 D.

STERNFRAME OF CAST STEEL.  
 RUDDERFRAME OF CAST STEEL.  
 RUDDER HEADSTOCK OF FORGED INGOT STEEL.

## ALL TO LLOYDS TESTS AND REQUIREMENTS.

MOULDED LENGTH OF SHIP IN FEET.	465
MOULDED DRAFT OF SHIP IN FEET.	29.44
AREA OF RUDDER ABAFT C.L. OF PINTLES IN SQ.FT.	194
CENTRE OF AREA OF RUDDER ABAFT C.L. OF PINTLES IN FEET	5.14
$A \times D = 194 \times 5.14$	997
SPEED AT SEA IN NAUTICAL MILES PER HOUR	16

FIRST LONGITUDINAL NUMERAL. \_\_\_\_\_ 17321  
RULE SIZES OF STERNPOST - CRUISER STERN. \_\_\_\_\_  $11\frac{1}{4} \times 3\frac{1}{2}$   
RULE DIAMETER OF SCREW SHAFTS. \_\_\_\_\_  $16\frac{3}{8}$

**STERNFRAME & RUDDER.**  
ALL APPROXIMATE DIMENSIONS TO BE VERIFIED BEFORE WORK IS COMMENCED.  
PATTERNS FOR CASTINGS ARE TO BE APPROVED BY SHIPBUILDERS REPRESENTATIVE.  
CARE IS TO BE TAKEN THAT SCANTLING IS ADHERED TO AS PAYMENT WILL  
BE MADE ON WEIGHT CALCULATED FROM SCANTLING SHOWN ON THIS PLAN.  
WEIGHTS OF CASTINGS AND FINISHES ARE TO BE PAINTED TO RESPECTIVE  
PARTS BEFORE LEAVING MAKERS PREMISES.

**STERNFRAME**

MOLDS AND/OR TRACINGS OF FULL SIZE SECTIONS OF STERNFRAME SHALL BE FORWARDED TO MAKERS BY SHIPBUILDERS AND THESE ARE TO BE WORKED TO IN PREFERENCE TO THIS PLAN.

RIVET HOLES AS SHOWN ON THIS PLAN ARE TO BE DRILLED BY MAKERS OF STERNFRAME IN THE WORKS TO TEMPLATES SUPPLIED BY SHIPBUILDERS.

RIVET HOLES ARE TO BE DRILLED 1/8" LARGER THAN DIAMETER OF RIVET TO SETTLING LINE OF CENTRE OF SHIP IS TO BE CUT IN ALONG BOTTOM AND BACK OF STERNFRAME AND AT POINTS OF ALL WEBS BY MAKERS AT THEIR WORKS.

**RUDDER.**  
BATTENS WILL BE SUPPLIED BY SHIPBUILDER GIVING EXACT POSITIONS OF GUDRONS ON STEENFRAME, HEIGHTS OF DECKS AND OVERALL LENGTH OF RUDDERHEAD. CASTINGS TO BE TAKEN THAT CENTRE LINE OF PINTLES AND CENTRE LINE OF RUDDER HEADSTOCK ARE IN SAME PLANE OR CLOSELY THERE TO. BOTH FORE AND AFT AND AFTWARD BAINPS. KEYWAYS ON RUDDER HEADSTOCK ARE TO BE MADE BY MAKERS TO PARTICULARS SUPPLIED BY SHIPBUILDERS AND/OR STEERING GEAR MAKERS.  
RUDDER HEADSTOCK IS TO BE MACHINED AS IT IS NECESSARY IN WAY OF STEERING QUANTITY, RUDDER CARRIER, ETC. BY MAKER.  
PINET RIVETS AS SHOWN ON THIS PLAN ARE TO BE DRILLED BY MAKERS OF RUDDER CASTINGS AT THEIR WORKS TO TEMPLATES SUPPLIED BY SHIPBUILDER. HOLES FOR CERTAIN RIVETS (INDICATED ON THIS PLAN) ARE TO BE DRILLED TO NEAR DIAMETER OF RIVETS TO BE FITTED. ALL OTHER RIVET HOLES ARE TO BE DRILLED  $\frac{1}{16}$  LARGER IN DIAMETER. TIGHTENERS TO BE FITTED TO ALL RIVETS. FOR TAP RIVETS AND SCREWS SHALL BE DRILLED AND TAPPED TO SIZE BY SHIPBUILDER.